

Date: Monday, 9/10/2007 1:19:02 PM
User: Kim Johnston

Process Sheet

SPLIT-2

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : ARM
Job Number : 34476 -2	
Estimate Number : 12883	
P.O. Number : N/A	Part Number : D3560043
This Issue : 9/10/2007 S.O. No. : N/A	Drawing Number : D3560 UNDER REVIEW
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL /MED FAB	Drawing Revision : BL
Previous Run : 32646	Material : N/A
Written By : _____	Due Date : 9/17/2007
Checked & Approved By : _____	Qty: 15 Um: Each
Comment : Est Rev:A New Issue 07.05.24 EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0500X05000	6061-T6 Bar .50" x 5.0"
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Comment: Qty.: 1.3598 f(s)/Unit Total : 16.3170 f(s)
6061-T6 Bar 0.50" x 5.00"
Batch: M105646

ml 07/09/20 (12)

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
Cut blanks 15.500" long

ml 07/09/20 (12)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA695 Rev: AA & Dwg D3560 Rev: C
2-C'sink 0.196" hole on manual mill as per dwg D3560
3-Deburr per dwg D3560

2507/09/22

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

2507/09/22

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

J.F 07/09/23 (12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 9/10/2007 1:19:02 PM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 34476

Part Number: D3560043

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

D35921

PLATE



Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)

PLATE

3-344260 3-34478-5 07-10-25 (5) 07-10-10 5

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld assembly as per dwg D3560

07-10-25 (5) 07-10-10 5

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07-10-26 (5)

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07-10-26 (5)

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

07-10-26 (5)

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

07-10-26

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07-10-26 (5X)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WPA

07-10-26 (5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: DD Date: 07/10/06
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 9/10/2007 1:19:02 PM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 34476

Part Number: D3560043

Job Number:



Seq. #:

Machine Or Operation:

Description :

140

QC21

FINAL INSPECTION/W/O RELEASE



(5)

Comment: FINAL INSPECTION/W/O RELEASE

DA 9/10/26

Job Completion



u 8.10.26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	34476
Description: Arm		Part Number:	D3560-3
Inspection Dwg: D3560 Rev: B		Page 1 of 1	

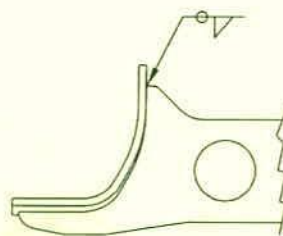
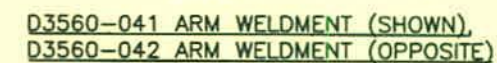
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.507	+0.000/-0.001	.5065	✓			
Ø0.196	+0.005/-0.001	.197	✓			
Ø1.000	+0.010/-0.001	1.004	✓			
Ø0.900	+0.010/-0.001	.999	✓			
0.500	+/-0.010	.495	✓			
0.250	+/-0.010	.250	✓			
0.275	+/-0.010	.274	✓			
0.188	+/-0.010	.193	✓			
2.000	+/-0.010	.2001	✓			
1.750	+/-0.010	1.750	✓			
1.702	+/-0.010	1.705	✓			
Ø0.385 x 100°	+/-0.010 x 0.5°	.380x100°	✓			
0.250 Deep	+/-0.010	.253	✓			

Measured by: J.L. / S.P.	Audited by: BG	Prototype Approval:	N/A
Date: 07/09/21	Date: 07-09-21	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.01.17	New Issue	KJ/JLM	
B	07.06.13	Dimensions updated per Dwg Rev B	KJ/JLM	








DETAIL A
(SCALE 1:1)

GENERAL NOTES

- 1) WELD PER QSI 004
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

RELEASE
07-06-29

C	07.06.19	REMOVE POWDER COAT	
B	07.01.15	REDESIGN AS WELDMENT, ADD POCKETS	
A	06.09.25	NEW ISSUE	
DESIGN	 DRAWN BY 	 DART AEROSPACE LTD. <small>MARKHAM, ONTARIO, CANADA</small>	
CHECKED	 APPROVED 	DRAWING NO. D3560	REV. 3
DATE	07.06.19	TITLE ARM WELDMENT	SHEET 1 OF 1 SCALE 1:1

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WITHOUT NOTICE
WORK ORDER
NO. 34476

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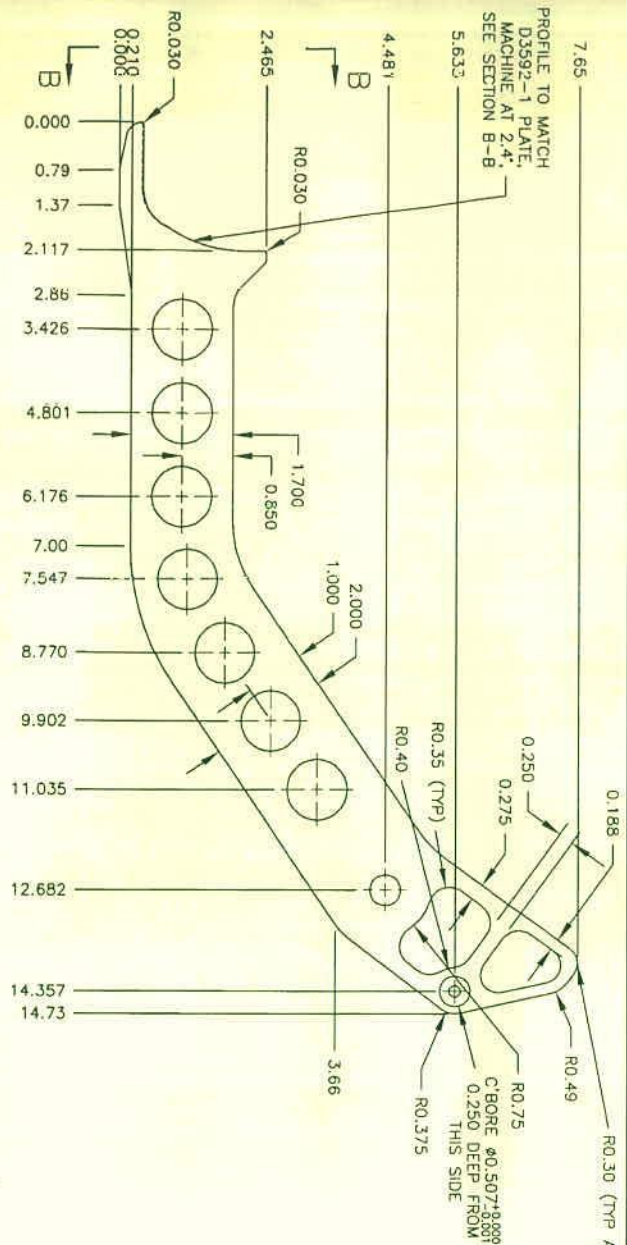
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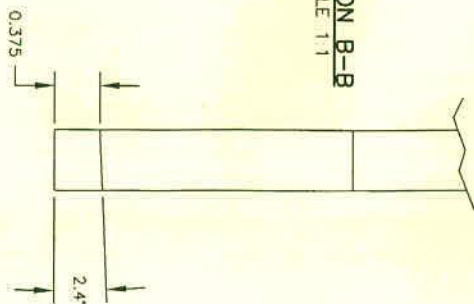
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- D3560-1 ARM (SHOWN), D3560-2 ARM (OPPOSITE)**
- 1) MATERIAL: 6061-T6 ALUMINUM, 0.500 THICK
(00-A-200/8 OR 00-A-250/11, REF DART SPEC. M6061T6B0.500)
 - 2) FINISH: NONE
 - 3) TOLERANCES ARE PER DART CSI 018 UNLESS OTHERWISE NOTED
 - 4) ALL DIMENSIONS ARE IN INCHES
 - 5) BREAK ALL SHARP CORNERS 0.005 TO 0.015

SECTION B-B
SCALE 1:1



RELEASED
07-06-24

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DATE		07.06.19				D3560	REV. C
TITLE		ARM WELDMENT					SHEET 2 OF 2
							SCALE 1:2

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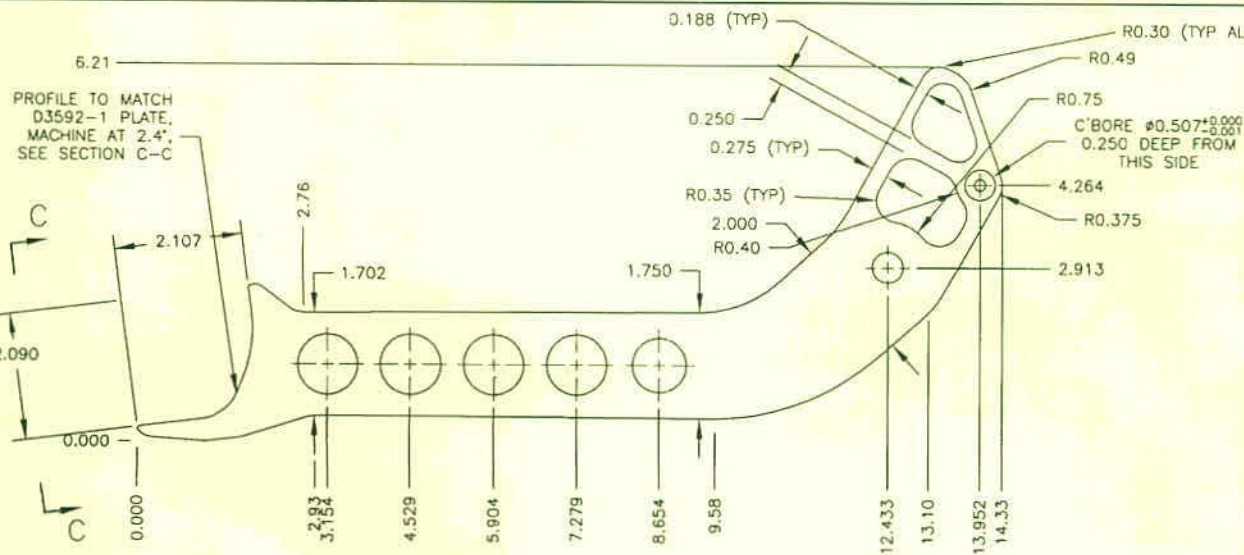
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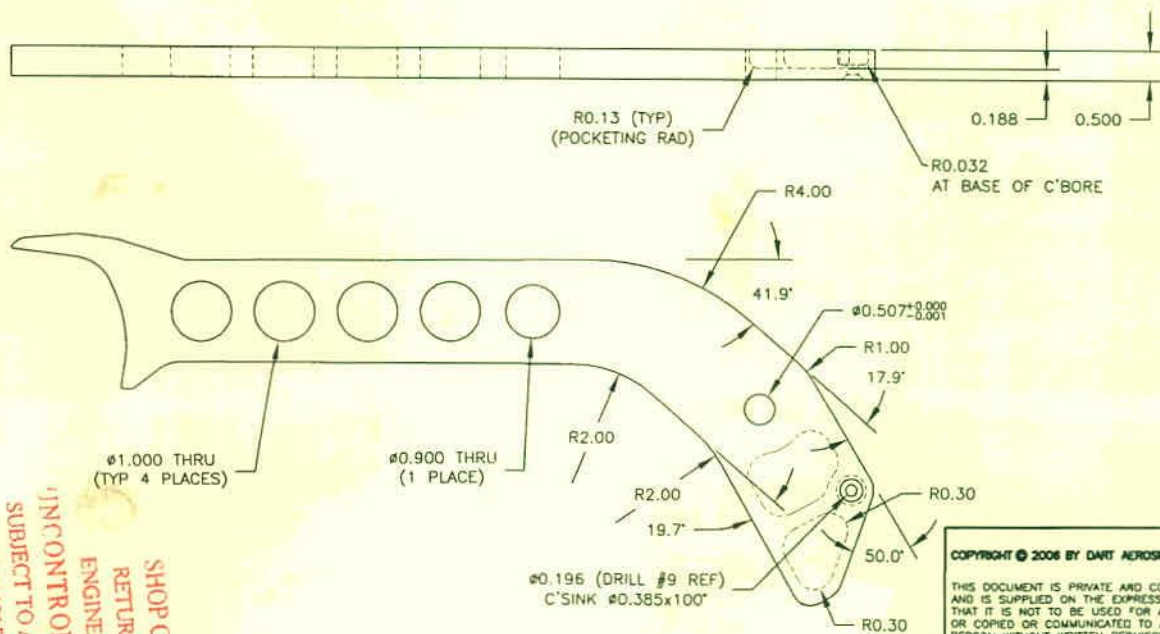
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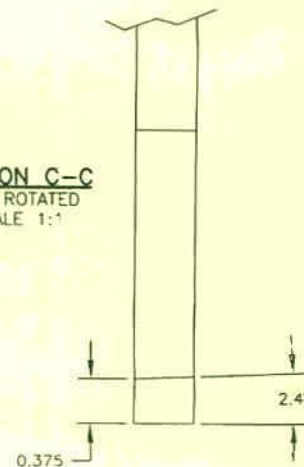


D3560-3 ARM (SHOWN), D3560-4 ARM (OPPOSITE)

- 1) MATERIAL: 6061-T6 ALUMINUM, 0.500 THICK
(QQ-A-200/8 OR QQ-A-250/11, REF DART SPEC. M6061T6B0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP CORNERS 0.005 TO 0.015



SECTION C-C VIEW ROTATED SCALE 1:1



RELEASED
07.06.19

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DESIGN	40	DRAWN BY	40	DART	DART AEROSPACE LTD. HAMPSHIRE, ENGLAND, CANADA
CHECKED	40	APPROVED	40	DRAWING NO.	D3560
DATE	07.06.19	TITLE	ARM WELDMENT	REV. C	SHEET 3 OF 3
				SCALE	1:2

